

**Notice of Allowability**

Application No.

10/501,104

Examiner

Daniel C. Crane

Applicant(s)

VESCOVINI, ALESSANDRO

Art Unit

3725

-- The MAILING DATE of this communication appears on the cover sheet with the correspondence address--

All claims being allowable, PROSECUTION ON THE MERITS IS (OR REMAINS) CLOSED in this application. If not included herewith (or previously mailed), a Notice of Allowance (PTOL-85) or other appropriate communication will be mailed in due course. **THIS NOTICE OF ALLOWABILITY IS NOT A GRANT OF PATENT RIGHTS.** This application is subject to withdrawal from issue at the initiative of the Office or upon petition by the applicant. See 37 CFR 1.313 and MPEP 1308.

1. ☒ This communication is responsive to Amendment filed September 26, 2007.
2. ☒ The allowed claim(s) is/are 1-30.
3. ☒ Acknowledgment is made of a claim for foreign priority under 35 U.S.C. § 119(a)-(d) or (f).
  - a) ☒ All    b) ☐ Some\*    c) ☐ None    of the:
    1. ☐ Certified copies of the priority documents have been received.
    2. ☐ Certified copies of the priority documents have been received in Application No. \_\_\_\_\_.
    3. ☒ Copies of the certified copies of the priority documents have been received in this national stage application from the International Bureau (PCT Rule 17.2(a)).

\* Certified copies not received: \_\_\_\_\_.

Applicant has THREE MONTHS FROM THE "MAILING DATE" of this communication to file a reply complying with the requirements noted below. Failure to timely comply will result in ABANDONMENT of this application.

**THIS THREE-MONTH PERIOD IS NOT EXTENDABLE.**

4. ☐ A SUBSTITUTE OATH OR DECLARATION must be submitted. Note the attached EXAMINER'S AMENDMENT or NOTICE OF INFORMAL PATENT APPLICATION (PTO-152) which gives reason(s) why the oath or declaration is deficient.
  5. ☐ CORRECTED DRAWINGS ( as "replacement sheets") must be submitted.
    - (a) ☐ including changes required by the Notice of Draftsperson's Patent Drawing Review ( PTO-948) attached
      - 1) ☐ hereto or 2) ☐ to Paper No./Mail Date \_\_\_\_\_.
    - (b) ☐ including changes required by the attached Examiner's Amendment / Comment or in the Office action of Paper No./Mail Date \_\_\_\_\_.
- Identifying indicia such as the application number (see 37 CFR 1.84(c)) should be written on the drawings in the front (not the back) of each sheet. Replacement sheet(s) should be labeled as such in the header according to 37 CFR 1.121(d).
6. ☐ DEPOSIT OF and/or INFORMATION about the deposit of BIOLOGICAL MATERIAL must be submitted. Note the attached Examiner's comment regarding REQUIREMENT FOR THE DEPOSIT OF BIOLOGICAL MATERIAL.

**Attachment(s)**

1. ☐ Notice of References Cited (PTO-892)
2. ☐ Notice of Draftsperson's Patent Drawing Review (PTO-948)
3. ☐ Information Disclosure Statements (PTO/SB/08),  
Paper No./Mail Date \_\_\_\_\_
4. ☐ Examiner's Comment Regarding Requirement for Deposit  
of Biological Material
5. ☐ Notice of Informal Patent Application
6. ☒ Interview Summary (PTO-413),  
Paper No./Mail Date Hereto.
7. ☒ Examiner's Amendment/Comment
8. ☐ Examiner's Statement of Reasons for Allowance
9. ☒ Other FAX of 11/27/07.

### **EXAMINER'S AMENDMENT**

An examiner's amendment to the record appears below. Should the changes and/or additions be unacceptable to applicant, an amendment may be filed as provided by 37 CFR 1.312. To ensure consideration of such an amendment, it MUST be submitted no later than the payment of the issue fee.

Authorization for this examiner's amendment to the claims was given in a telephone interview with Mr. John Wahl on November 27, 2007.

### **IN THE SPECIFICATION**

**Before the first line of the specification, ---This application is a 371 of PCT/IT03?00106, filed February 26, 2003.---** has been inserted therein.

### **IN THE CLAIMS**

**Claim 1 (Currently Amended)** A procedure for the cold processing of tubular metal elements or other elements with dead or through holes, nuts, comprising the following machining steps:

- (a) preparing a blank of full metal material from rolls;
- (b) straightening the full metal material after unrolling from the skein;
- (c) cutting the metal material into pieces of a determined length;
- (d) passing each piece sequentially through a plurality of work stations of a work centre comprising several cold hydraulic presses, ~~wherein operation of the hydraulic presses is controlled to limit the temperature of the work pieces to less than 700 degrees during processing~~

in order to obtain a blank element presenting one or two longitudinally opposite dead holes separated by a central transverse section, wherein each piece is first cold machined by a hydraulic press, then extracted from said hydraulic press by means of a suitable manipulator robot and conveyed to an adjacent hydraulic press for a subsequent cold machining operation; and

- (e) through drilling of the blank to remove the central traverse section;
- wherein the metal elements have a diameter greater than 30 mm.

**Claim 2 (Currently Amended)** A procedure for the cold processing of metal elements, comprising the following machining steps:

- (a) preparing a blank of full metal material in the form of bars, which bars are loaded in bundles in a bar sectioning plant;

- ~~(b) — straightening the full metal material;~~

- ~~(e)~~(b) cutting the metal ~~material~~ bars into pieces of a determined length after being presented from the bar sectioning plant; and

- ~~(d)~~(c) passing each piece sequentially through a plurality of work station of a cold multi-hydraulic-press plant, ~~wherein operation of the hydraulic presses is controlled to limit the temperature of the work pieces to less than 700 degrees during processing~~ in order to obtain a finished element with or without swarf or waste, wherein each piece if first cold machined by a hydraulic press, then extracted from said hydraulic press by means of a suitable manipulator robot and conveyed to an adjacent hydraulic press for a subsequent cold machining operation;

wherein the metal elements have a diameter greater than 30 mm.

**Claim 3 (Currently Amended)** A procedure for the cold processing of tubular metal elements or other elements with dead or through holes, nuts, comprising the following machining steps:

- (a) preparing a blank of full metal material from rolls, wherein setting up and preparation of the full blank differs according to the metal material used;
  - (b) straightening the full metal material after the material is unrolled from the skein;
  - (c) cutting the metal material into pieces of a determined length;
  - (d) passing each piece sequentially through a plurality of work stations of a work centre comprising several cold hydraulic presses, ~~wherein operation of the hydraulic presses is controlled to limit the temperature of the work pieces to less than 700 degrees during processing~~ in order to obtain a blank element presenting one or two longitudinally opposite dead holes separated by a central transverse section, whereby each piece is first cold machined by a hydraulic press, then extracted from said hydraulic press by means of a suitable manipulator robot and conveyed to an adjacent hydraulic press for subsequent cold machining operation; and
  - (e) through drilling of the blank to remove the central traverse section;
- wherein the metal elements have a diameter greater than 30 mm.

**Claim 7 (Currently Amended)** The procedure according to claim 2 ~~1, carried out on starting material in the form of rolls, in which~~ wherein previously washed metal material is straightened by loading it on a wire-straightening unit designed to unroll the skein.

**Claim 8 (Currently Amended)** The procedure according to claim 2, ~~carried out on starting material in the form of bars, in which these bars are loaded in bundles in a bar section plant and in which~~ wherein the bars are presented at the cutting station in a synchronized way according to the needs of a machining centre consisting of the presses.

**Claim 16 (Currently Amended)** A plant for the implementation of a procedure for the cold processing of tubular metal elements or other elements with dead or through holes, nuts, comprising the following machining steps:

- (a) preparing a blank of full metal material from rolls;
  - (b) straightening the full metal material the material is unrolled from the skein;
  - (c) cutting ~~[[of]]~~ the metal material into pieces of a determined length;
  - (d) passing the pieces sequentially through a plurality of work stations of a work centre comprising several presses in order to obtain a blank element presenting one of two longitudinally opposite dead holes separated by a central transverse section; and
  - (e) through drilling ~~of~~ the blank by removal of this central traverse section;
- wherein the metal elements having a diameter greater than 30 mm,
- wherein the plant comprises a series of cold hydraulic presses adjacent to each other, designed to carry out a successive series of pressing operation on pieces to be machined wherein each piece is first cold machined by a hydraulic press, ~~wherein operation of the hydraulic presses is controlled to limit the temperature of the work pieces to less than 700 degrees during processing~~, then extracted from said hydraulic press by means of a suitable manipulator robot and conveyed to and adjacent hydraulic press for a subsequent cold machining operation.

**Claim 20 (Currently Amended)** A procedure for the cold processing of metal elements, comprising the following machining steps:

(a) preparing a blank of full metal material in the form of bars, which bars are loaded in bundles in a bar sectioning plant, in which the setting up and preparation of the full blank differs according to the metal material used;

~~(b) —straightening the full metal material;~~

~~(e)(b)~~ cutting of the metal ~~material~~ bars into pieces of a determined length; and

~~(d)(c)~~ passing each piece sequentially through a plurality of work station of a cold multi-hydraulic-press plant, ~~wherein operation of the hydraulic presses is controlled to limit the temperature of the work pieces to less than 700 degrees during processing~~ in order to obtain a finished element with or without swarf or waste, wherein each piece is first cold machined by a hydraulic press, then extracted from said hydraulic press by means of a suitable manipulator robot and conveyed to an adjacent hydraulic press for a subsequent cold machining operation; wherein the metal elements have a diameter greater than 30 mm.

**Claim 28 (Currently Amended)** A plant for the implementation of a procedure for the cold processing of metal elements comprising the following machining steps:

(a) preparing a blank of full metal material in the form of bars, which bars are loaded in bundles in a bar sectioning plant;

~~(b) —straightening the full metal material;~~

~~(e)(b)~~ cutting of the metal ~~material~~ bars into pieces of a determined length; and

(d)(c) passing the pieces sequentially through a plurality of work station of a multi-  
hydraulic-press plant in order to obtain a finished element with or without swarf or waste;  
wherein the metal elements have a diameter greater than 30 mm,  
wherein the plant comprises a series of cold hydraulic presses adjacent to each other;  
~~wherein operation of the hydraulic presses is controlled to limit the temperature of the work~~  
~~pieces to less than 700 degrees during processing,~~ designed to carry out a successive series of  
cold pressing operations on pieces to be machined wherein each piece is first cold machined by a  
hydraulic press, then extracted from said hydraulic press by means of a suitable manipulator  
robot and conveyed to an adjacent hydraulic press for a subsequent cold machining operation.

## INQUIRIES

Any inquiry concerning this communication or earlier communications from the  
examiner should be directed to Examiner D. Crane whose telephone number is **(571) 272-4516**.  
The examiner's office hours are 7:00 AM – 3:30 PM, Monday through Friday.

Documents related to the instant application may be submitted directly by facsimile  
transmission at all times. The Examiner's Fax number is **(571) 273-4516**. Applicant(s) is(are)  
reminded to clearly mark any transmission as "DRAFT" if it is **not** to be considered as an official  
response. The Office Facsimile Center number is **(571) 273-8300**.


Information regarding the status of an application may be obtained from the Patent  
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applications is available through Private PAIR only. For more information about the PAIR system, see <http://pair-direct.uspto.gov>. Should you have questions on access to the Private PAIR system, contact the Electronic Business Center (EBC) at 866-217-9197 (toll-free).

DCCrane  
November 27, 2007



**Daniel C. Crane**  
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